

Split
Work Order ID 136276-2

Friday, August 28, 2015 2:16:28 PM

136276

Page 1

Item ID: 646.3001 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lower Cutter Assy
 Start Date: 8/28/2015 Start Qty: ~~3.00~~ *6* Cust Item ID:
 Required Date: 8/28/2015 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: SA/LL Date: 150901 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3000	N/C								
110	Pick Kit	0.00				<u>3</u>			DAS 41 9-88 15-12-17
110									
Packaging	Memo	0.00							
Packaging									
120		0.00				<u>3</u>			DAS 41 9-88 15-12-17
120									
Small Fab	Memo	0.07							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.								
	A/R RTV LOCTITE 598: <u>133275</u>								
	exp. date: <u>5/17</u>								

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Item ID: 646.3001 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
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Start Date: 8/28/2015 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 8/28/2015 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				(3)	15-12-17		DAS 9 9-89
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>CCK18</u> Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***	0.00 0.00				3	DEC 18 2015		
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ	DEC 18 2015		

SJA 20151218

Picklist Print

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Work Order ID: 136276

136276

Parent Item: 646.3001

646.3001

Parent Item Name: Lower Cutter Assy

Start Date: 8/28/2015

Required Date: 8/28/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty or Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21042L08

Purchased

No

Each

896.0000

114

MS21042L 08

Nut

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

106

m131697

106

ST304

689

123900

16

m128401

102

m128429

3

m131317

68

m132930

500

m133483 X57 ~~8/28/15~~

646.3010

Manufactured

No

110

Each

7.0000

1

6

646.3010

LH Half

Location

Loc Qty

Loc Code

MF

7

128968

7

3X 136265

646.3011

Manufactured

No

110

Each

19.0000

1

6

646.3011

RH Half

Location

Loc Qty

Loc Code

MF

19

126778

19

6

Picklist Print

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Work Order ID: 136276

Parent Item: 646.3001

Parent Item Name: Lower Cutter Assy

136276

646 3001

Start Date: 8/28/2015

Required Date: 8/28/2015

Start Qty: 6.00

Required Qty: 6.00

646.3012 Manufactured No 110 Each 16.0000 1 6

646 3012

Lower Guide

SP

Location

Loc Qty

Loc Code

MF 16
122950 4
128426 4
130736 8

2
4

646.3013 Manufactured No 110 Each 13.0000 1 6

646 3013

Blade

SP

Location

Loc Qty

Loc Code

MF 13
127805 7
130894 6

6

646.3014 Manufactured No 110 Each 8.0000 1 6

646 3014

Blade

SP

Location

Loc Qty

Loc Code

MF 8
128449 2
130960 6

2 x 136174
4

646.3015 Manufactured No 110 Each 0.0000 1 6

646 3015

Blade

B136216

(3x)

SP
3x 138370

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Shop Packet Print

Page 2

Picklist Print

Friday, August 28, 2015 1:48:52 PM

Work Order ID: 136276

Parent Item: 646.3001

Parent Item Name: Lower Cutter Assy

136276***646 3001***

Start Date: 8/28/2015

Required Date: 8/28/2015

Start Qty: 6.00

Required Qty: 6.00

MS27039-08-19

Purchased

No

110

Each

552.0000

19

114

**

0

0

0-85

MS27039-08-19

Screw

LocationLoc QtyLoc Code

ST273A

523

273

250

29

29

ST281

m131264

110

Each

2,488.000

38

228

**

0

0

0-85

NAS1149FN832P

Purchased

No

NAS1149FN832P

Washer

LocationLoc QtyLoc Code

ST260a

1500

125268

1500

st268

988

125268

67

M130388

921

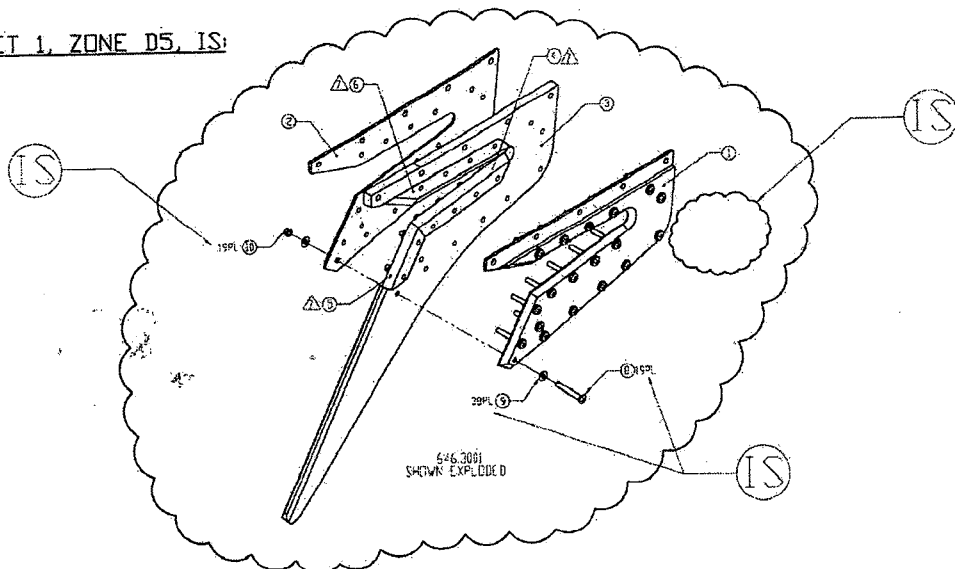
m133209

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 02195		SHEET 1 OF 4	
DWG NO. 646.3000	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
DWG TITLE: LOWER CUTTER ASSY		EFFECT ON DWG: ☐ INC. ☒ UNINC.	
APPROVED BY: ENGR [Signature]	MFG [Signature]	QC [Signature]	EFF: NEXT ORDER
REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS			

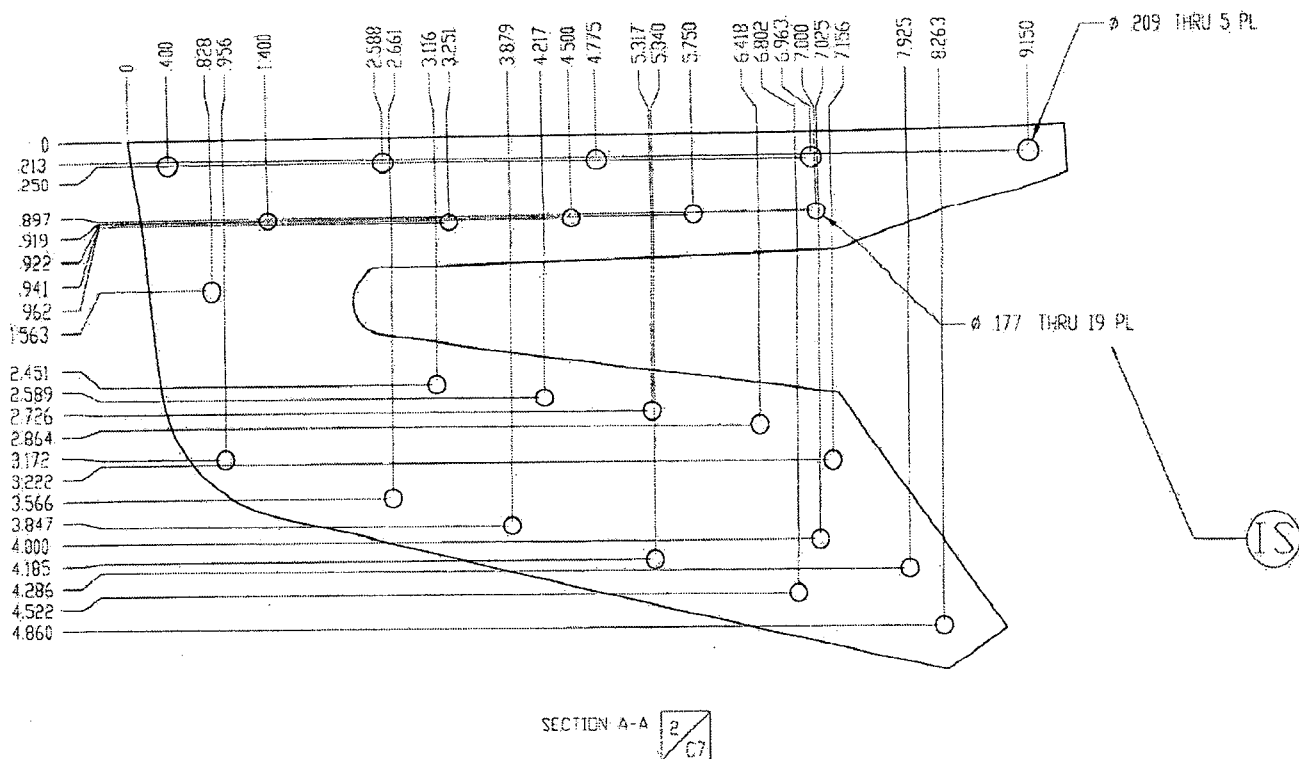
TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

SHEET 1, ZONE D5, IS:



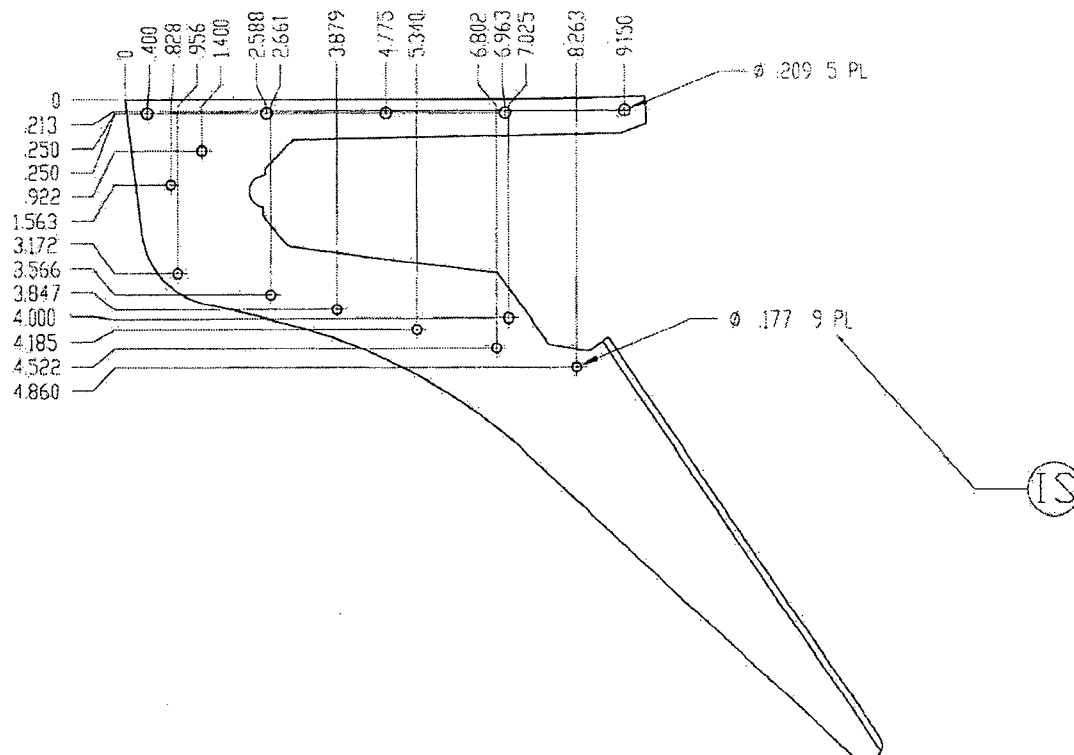
10	R	601.1541	19	LOCKNUT	MS21042L08
9	R	601.2764	38	WASHER	NAS1149FN832P
8	R	601.2765	19	SCREW	MS27039-0819
7	D	601.2766	2	RIVET	MS20470AD5-18
			.3001		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☒ INSTALL INSTRU ☒ ICA ☐ FMS ☒ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR
				DER REVIEW REQUIRED ☐ YES ☒ NO	

SHEET 3 IS:



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 5 IS:

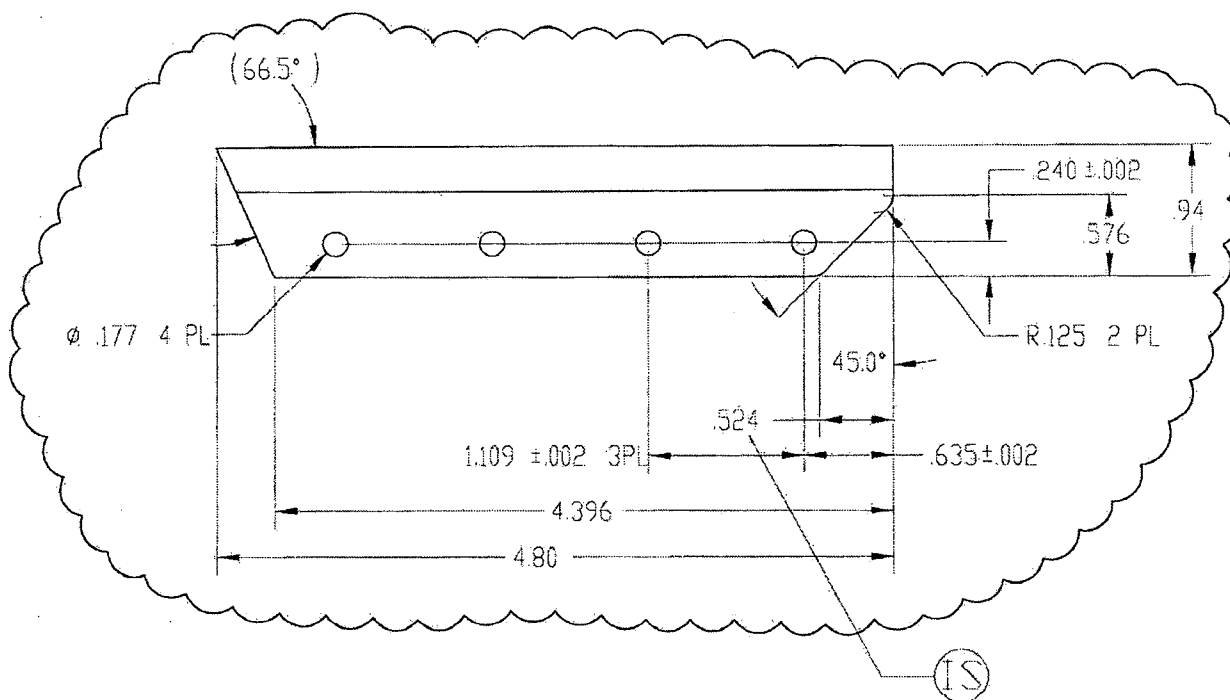


SECTION F-F



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 6, ZONE C4, IS:



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

[illegible]

▲ MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12

646.3001
SHOWN EXPLODED

QTY	11	601.2045	RTV LOCITE OR
17	10	601.1868	LOCKWASH
34	9	601.2764	WASHER
17	8	601.2765	SCREW
2	7	601.2766	RIVET
1	6	646.3015	BLADE
1	5	646.3014	BLADE
1	4	646.3013	BLADE
1	3	646.3012	LOWER GUIDE
1	2	646.3011	RH HALF
1	1	646.3010	LH HALF
1	1	646.3001	LOWER CUTTER

4 FINISH: PRIME (AW MIL-P-23377) TYPE I CLASS N

5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED

6. IDENTIFY IAW MPP-120

 APPLY F/N 11 AS REQUIRED TO ALL FAYING SURFACES OF F/N 4, 5 & 6 UPON ASSEMBLY

8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE

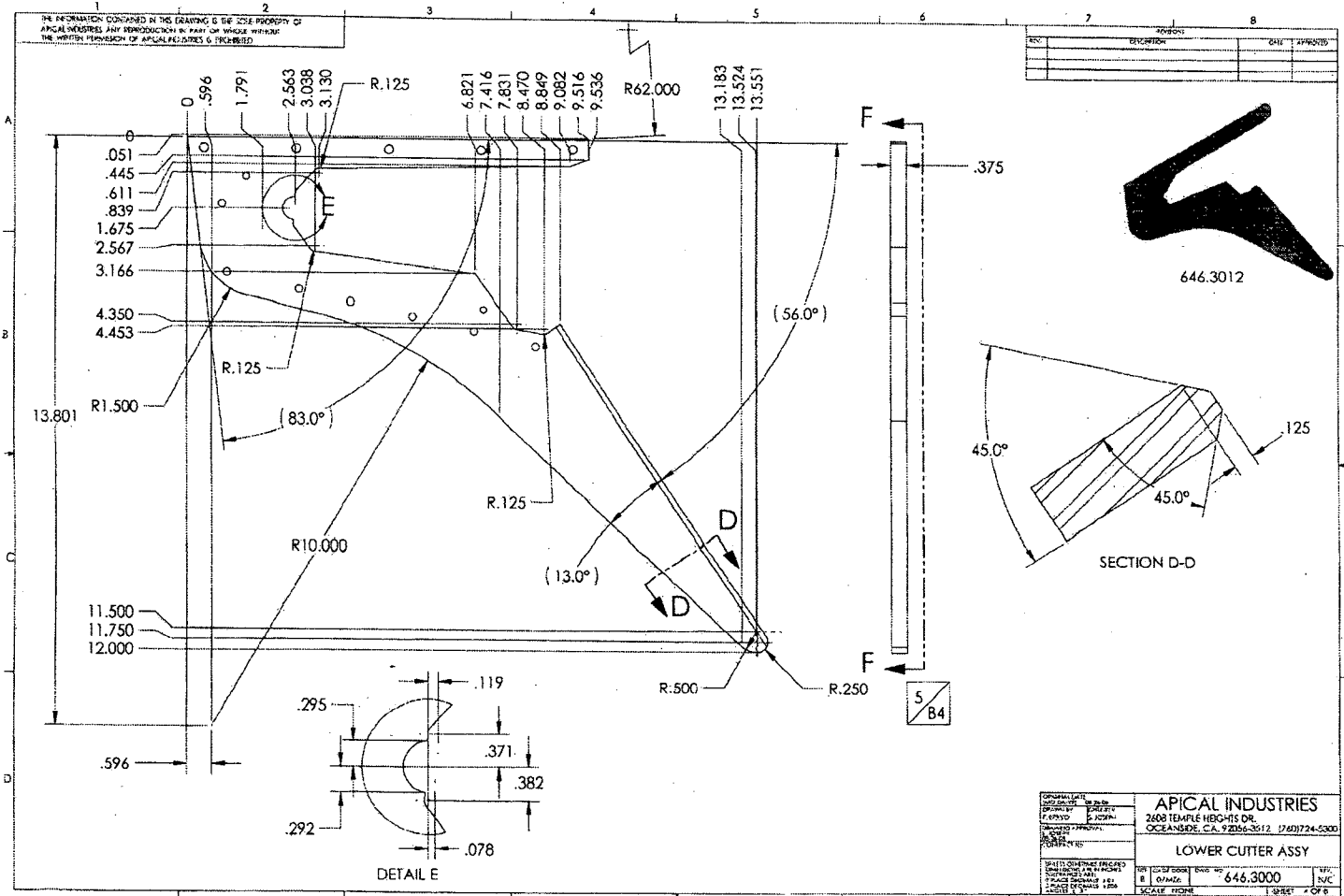
UNINCORPORATED ECN(S)

02195

646.3001
SHOWN EXPLODED

[illegible]

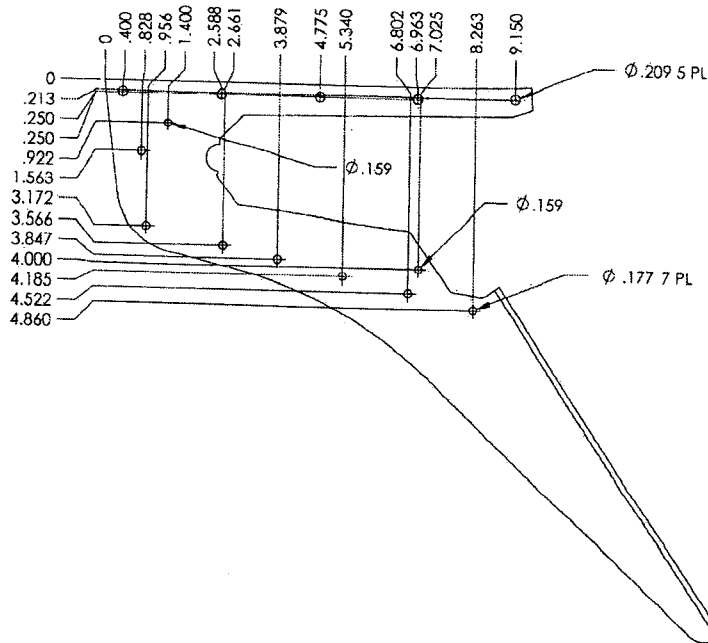
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COMPANY: APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3012 (760) 724-5300	
PROJECT: LOWER CUTTER ASSY	
DATE: 10/23/2008 DRAWN BY: [blank] CHECKED BY: [blank] SCALE: NONE	PART NO: 646.3000 SHEET: 1 OF 1

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

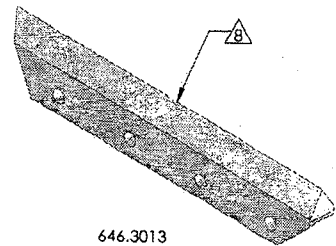


SECTION F-F 4/B6

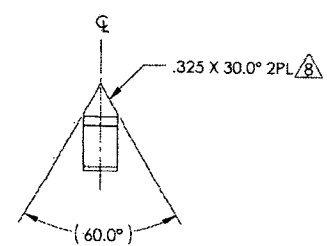
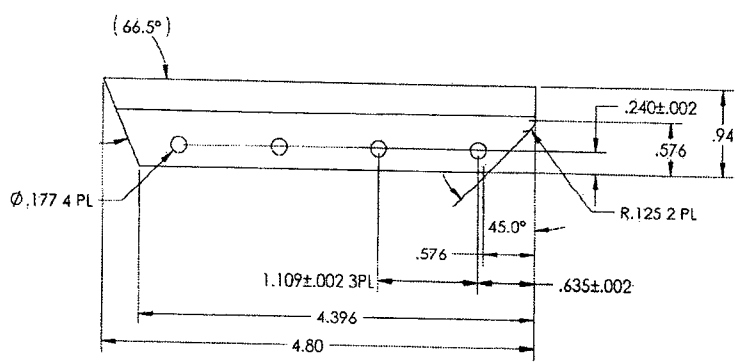
APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92066-3512 (760) 724-5300	
LOWER CUTTER ASSY	
DESIGNED BY: [blank] DRAWN BY: [blank] CHECKED BY: [blank] DATE: [blank]	REV: [blank] DATE: [blank]
PART NO: 646.3000 SCALE: NONE	REV: [blank] DATE: [blank]

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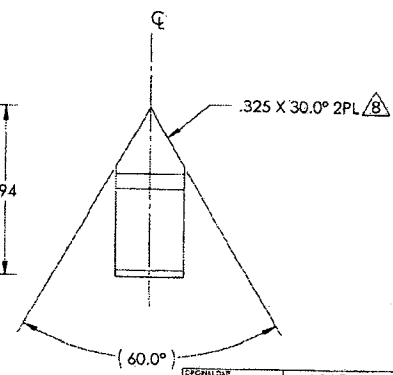
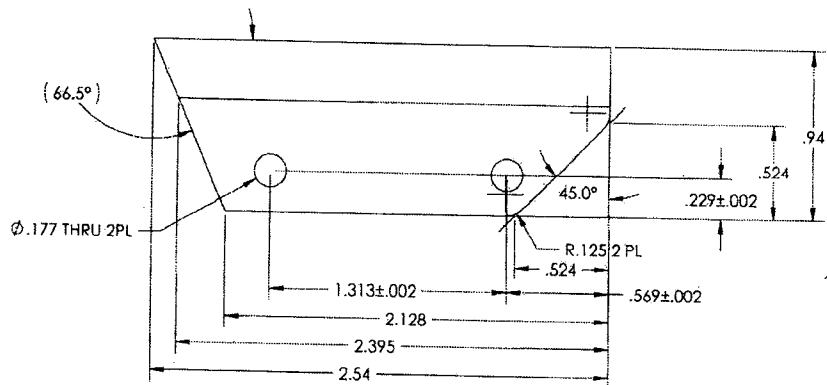
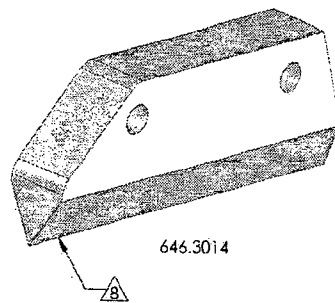
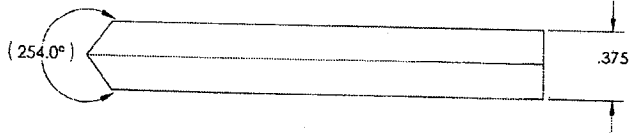
646.3013



DESIGNED BY: DRAWN BY: CHECKED BY: APPROVED BY: DATE: SCALE:	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 LOWER CUTTER ASSY 646.3000 SCALE: NONE	SHEET NO. OF 8
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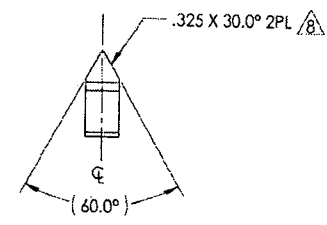
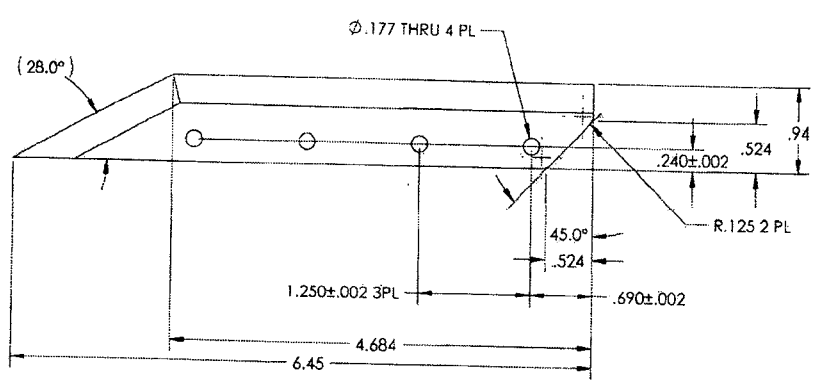
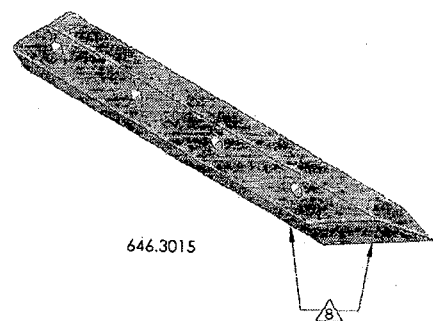
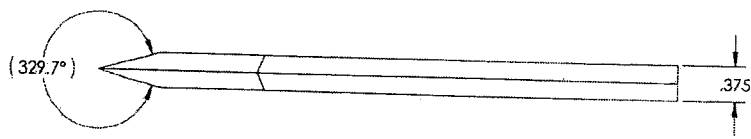
REV	DESCRIPTION	DATE	APPROVED



DESIGNED BY DRAWN BY CHECKED BY DATE	APICAL INDUSTRIES 2006 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3312 1760/724-5300 LOWER CUTTER ASSY 646.3000 SCALE: NONE 1 SHEET OF 8
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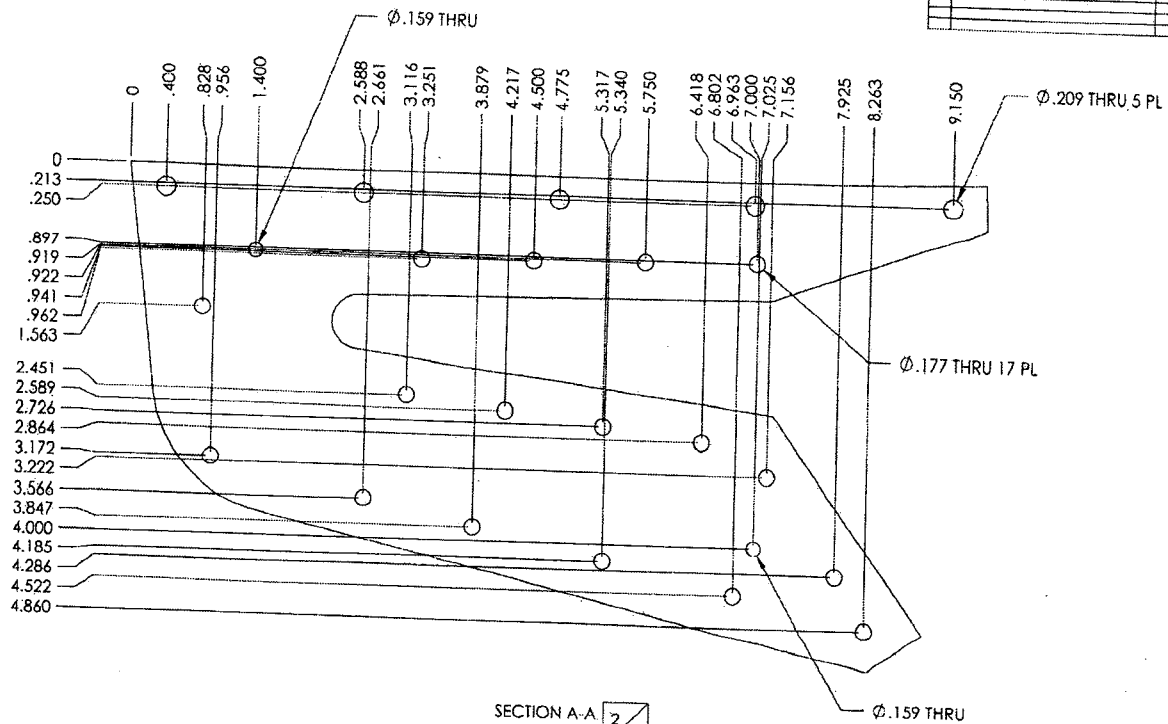
REV.	DESCRIPTION	DATE	APPROVED



GENERAL NOTE: 1. ALL DIMENSIONS ARE IN INCHES 2. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED 3. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED 4. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED 5. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED 6. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED 7. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED 8. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED 9. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED 10. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED	APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 LOWER CUTTER ASSY 646.3000 SCALE: NONE SHEET 8 OF 8
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REV.	DESCRIPTION	DATE	APPROVED



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